

PTD(1)



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3282-041

Job Sheet 212401



Part No: D3282-041

Job Qty: 10 pcs

Part Name: Float Web (206L/407)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/21/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/30/20

Description:

Type: Stock

Note: DWG REV D IPP Rev:B 05.09.23 Procedure change KJ/JLM IPP REV:C 11.09.20 remove LPS as per dwg
revD DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	10 pcs	9/28/20		0.00	1.67	Skidtubes - 1		PTO
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	HAAS 4 Axis - B4B	10 pcs	9/29/20		0.31	16.39	HAAS - 1 - B4B		DAS 03 20.8.26
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	10 pcs	9/29/20		0.00	0.00	QC 8 - 12		PLA / P 20/09/20
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		



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CANADA
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www.dartaerospace.com

Container No: S296192



Part: D3282-041

Job No: 212401

Serial No/Batch: S296192

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/26/20

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						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						QC 8 - 73	
						QC 8 - 82	
140	Handfinish - 1-1 Chemical-B4B	10 pcs	9/29/20	0.00	2.33	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	TF 05, 11, 2020
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	10 pcs	9/29/20	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	

				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MGL 20-10-15
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
160 Skidtubes - 2 - B4B	10 pcs	9/30/20	0.00 8.75	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGL 20-10-16
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 5	10 pcs	9/30/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
180 Packaging 3-1 - Stock - B4B	10 pcs	9/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B	M66 20-10-16				
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				Packaging 3 - 37 - B4B	DAS				
				190 QC 21 - SA	10 pcs	9/30/20	0.00 0.00	QC 21 - SA - 21	21
								QC 21 - SA - 70	9-30
								QC 21 - SA - 9	
								QC 21 - SA - 77	

OCT 16 2020

Part Op 100 - (Skidtubes) 1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA579 & Dwg D3282 2-Deburr
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skidtubes) 1-Install doublers as per Dwg D3282.
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2792-130	Extrusion	10 pcs (1 ea)	100-Skidtubes - 1	F12809⑦ / 525504③
D3283-1	Doubler	20 pcs (2 ea)	160-Skidtubes - 2 - B4B	5218759(6X) / 5297809
MS20470AD4-7	Rivet, Universal Head	570 Ea (57 ea)	160-Skidtubes - 2 - B4B	513 5291169

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2792-130	10	71	0
160-Skidtubes - 2 - B4B	D3283-1	20	6	0
	MS20470AD4-7	570	845	0

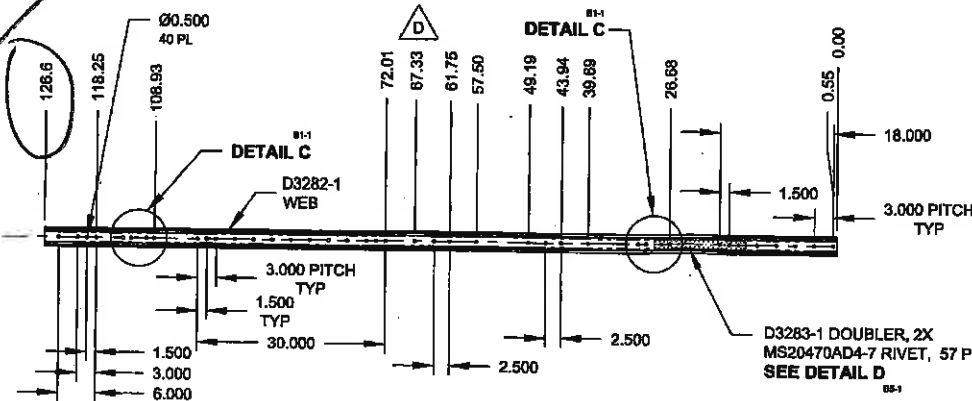
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Float Web	126.600inches ± 0.010	126.610 126.590		126.562
2	Float Web	1.500inches ± 0.010	1.510 1.490		1.5
3	Float Web	3.000inches ± 0.010	3.010 2.990		3.0
4	Float Web	6.000inches ± 0.010	6.010 5.990		6.0
5	Float Web	1.250inches ± 0.010	1.260 1.240		1.250
6	Float Web	30.000inches ± 0.010	30.010 29.990		30.000
7	Float Web	1.500inches ± 0.010	1.510 1.490		1.5
8	Float Web	72.010inches ± 0.030	72.040 71.980		72.0
9	Float Web	61.750inches ± 0.030	61.780 61.720		61.850
10	Float Web	57.500inches ± 0.030	57.530 57.470		57.5
11	Float Web	49.190inches ± 0.030	49.220 49.160		49.187
12	Float Web	43.940inches ± 0.030	43.970 43.910		43.940
13	Float Web	39.690inches ± 0.030	39.720 39.660		39.690
14	Float Web	26.680inches ± 0.030	26.710 26.650		26.680
15	Float Web	0.550inches ± 0.030	0.580 0.520		0.545
16	Float Web	1.970inches ± 0.010	1.980 1.960		1.970
17	Float Web	2.380inches ± 0.030	2.410 2.350		2.379
18	Float Web	0.050inches ± 0.030	0.080 0.020		0.040

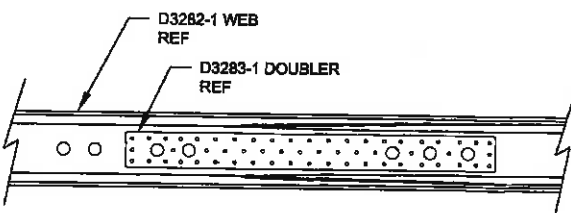
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8 7 6 5 4 3 2 1

126.6"

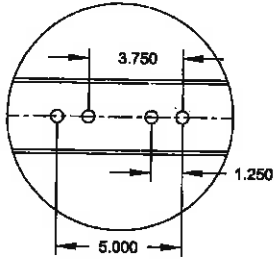


D3282-041 WEB



DETAIL D

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 712401 M5
20-08-21



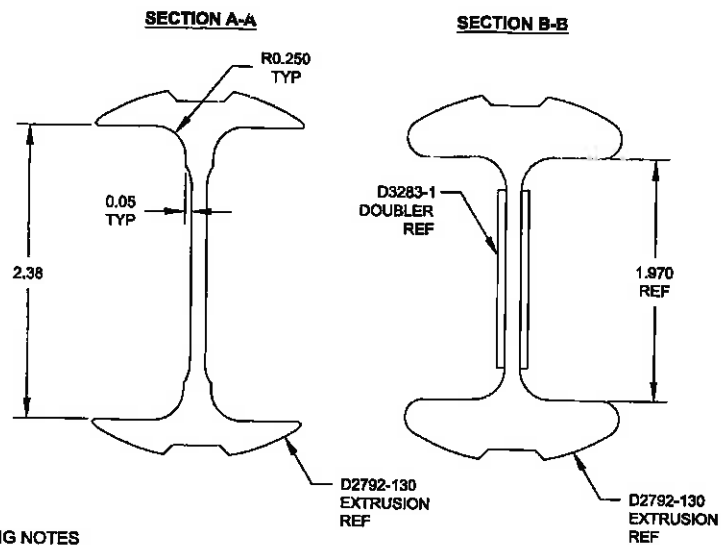
DETAIL C

NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY

RELEASED
2011-09-12

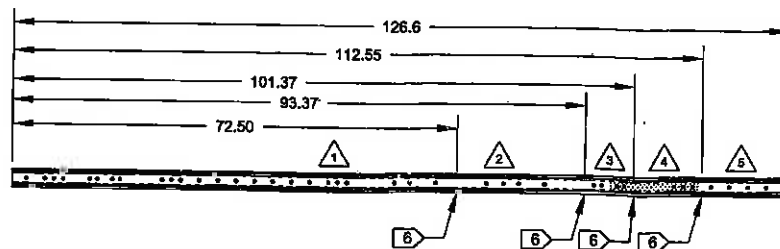
- NOTES:
- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 20.0 lbs
 - 8) SEE PAGE 2 FOR MACHINING DETAILS

D	ADD ADDITIONAL HOLE (ZN D8-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	06.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3282	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROVIDED AS INFORMATION AND IS NOT TO BE USED FOR ANY PURPOSE OF COPIES OR REPRODUCTION WITHOUT THE EXPRESS PERMISSION OF DART AEROSPACE USA, INC.	



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3282	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
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Entered:

Date:

OCT 20 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8586

Route update only

Job: <u>212401</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>D3282-041</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☒ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>20.8.26</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u> ^{PD}						MRB (QSI042)	
Description Work Order Deviation				Disposition						PD 20-8-26	
while manufacturing Found that <u>2</u> ^{PD} pcs of D2792-130 extension was twisted and cannot be used.				Scrap & Destroy. QTY: D2792-130 F128109 <u>x1</u> D2792-130 S255044 x1 ^{PD}						Completed By DAS 03 9-89 <u>20.8.26</u> Lead hand / Supervisor DAS 03 9-89 <u>20.8.26</u> QC / QA Coordinator <u>20.8.26</u>	
Root Cause				FAULT CATEGORY							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ ☒ Broken/Damage/Defect Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
Other/Details:											